

Work Order ID 111430 - 2

January-15-14 1:06:08 PM

111430

Page 1

Item ID: D3655-1

Accept

Revision ID:

Item Name: Panel

Start Date: 1/15/14

Start Qty: 1.00

1

Required Date: 1/31/14

Req'd Qty: 1.00

1

Reference:

Approvals: Process Plan: MLJ

Date: 14-01-16 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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D3655	Rev B	0.00							
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100		0.00							
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100

FLOW WATER JET

Waterjet

Memo

0.00

DAS

23

14-09-9

9-89

FLOW CNC Waterjet Light.
Lexan .093 Grey

1-Cut as per Dwg D3655 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

DAS

23

14-09-9

9-89

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

DAS

38

14-09-9

9-89

120

QC

Memo

0.00

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS													
Part No. _____	Rework	Scrap	Use-as-is	Skid-tube	Machining	Thermoforming	Large Fab	Crosstube	Small Fab	Finishing	Composite	Water Jet	Prod. Eng. Coor.	Rec/Store/Packaging	Supplier	Engineering	
NCR No. _____	Suspected Unapproved															Quality	Other

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
		Bending		Bend		Folio/Program		Outside Dimensions		Pressure/Forced	
		Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance		Set-up	
		Cracks		Broken/Damage/Defect		Hardware		Part Incorrect		Temperature/Cure	
		Crimp/Kink/Ripple/Wave		Burrs		Inspection Incomplete/Unqualified		Part Lost/Missing		Weld	
		Cuffs		Contamination		Instructions Incomplete/Unclear		Part Moved		Wrong Stock Pulled	
		Crushing		Countersink		Misaligned/off center		Positioned Wrong		Other	
		Heat Treat		Cut Too Short		Mislabeled		Power Loss/Surge			
		Inspection Strip in Tube		Drawing		Misread					
		Marks/Chatter		Drill Holes		Off-set					
		Turning Sequence		Finish		Out of Calibration					
		Wave/Twist in Tube		Fit/Function		Out of Sequence					

Work Order ID 111430

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Page 2

Item ID: D3655-1

Accept

Revision ID:

Item Name: Panel

Start Date: 1/15/14

Start Qty: 1.00

1

Required Date: 1/31/14

Req'd Qty: 1.00

1

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/
Work Center ID

130

Operation
Description

Identify as per dwg & Stock Location: 8178

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Packaging

Packaging

Memo

0.00

01

26/9/11

140

QC21- Final Inspection - Work Order Release

0.00

14/9/12 AF

140

QC

Quality Control

Memo

0.00

MF
14-9-11

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS				
Part No. _____	Rework	Scrap	Use-as-is	Skid-tube	Crosstube	Water Jet	Engineering	
NCR No. _____	Suspected Unapproved			Machining	Small Fab	Prod. Eng. Coor.	Quality	
				Thermoforming	Finishing	Rec/Store/Packaging	Other	
				Large Fab	Composite	Supplier		

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General			
Bending	Bend	Folio/Program	Outside Dimensions	Pressure/Forced
Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance	Set-up
Cracks	Broken/Damage/Defect	Hardware	Part Incorrect	Temperature/Cure
Crimp/Kink/Ripple/Wave	Burrs	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld
Cuffs	Contamination	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled
Crushing	Countersink	Misaligned/off center	Positioned Wrong	
Heat Treat	Cut Too Short	Mislabeled	Power Loss/Surge	Other
Inspection Strip in Tube	Drawing	Misread		
Marks/Chatter	Drill Holes	Off-set		
Turning Sequence	Finish	Out of Calibration		
Wave/Twist in Tube	Fit/Function	Out of Sequence		

Picklist Print

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Work Order ID: 111430

Parent Item: D3655-1

Parent Item Name: Panel

Start Date: 1/15/14

Required Date: 1/31/14

Start Qty: 1.00

Required Qty: 1.00

Comments: Ext. Rev. A 07/12/13

IPP Rev:B 08-03-06 prototype DD verified by:EC

IPP Rev:C 08-04-07 revA DD verified by:EC

IPP Rev. D 08/08/16 Dwg. Update. DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07 GE PLASTICS LEXAN SHEET		Purchased	No			100	sf	1,783.2600	3.5366	4			DAS 23 9-89

Location	Loc Qty	Loc Code
MAT023	1783.26	
114459	229.26	
123105	38	
124501	1516	124501

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS														
Part No. _____	Rework	Scrap	Use-as-is	Skid-tube	Machining	Thermoforming	Large Fab	Crosstube	Small Fab	Finishing	Composite	Water Jet	Prod. Eng. Coor.	Rec/Store/Packaging	Supplier	Engineering	Quality	Other
NCR No. _____	Suspected Unapproved																	

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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	Bending	General	Folio/Program	Outside Dimensions	Pressure/Forced
	Centre Not Concentric	Bend	Grain	Over/Under tolerance	Set-up
	Cracks	BOM/Route	Hardware	Part Incorrect	Temperature/Cure
	Crimp/Kink/Ripple/Wave	Broken/Damage/Defect	Inspection Incomplete/Unqualified	Part Lost/Missing	Weld
	Cuffs	Burrs	Instructions Incomplete/Unclear	Part Moved	Wrong Stock Pulled
	Crushing	Contamination	Misaligned/off center	Positioned Wrong	
	Heat Treat	Countersink	Mislabeled	Power Loss/Surge	Other
	Inspection Strip in Tube	Cut Too Short	Misread		
	Marks/Chatter	Drawing	Off-set		
	Turning Sequence	Drill Holes	Out of Calibration		
	Wave/Twist in Tube	Finish	Out of Sequence		
		Fit/Function			

DART AEROSPACE LTD	Work Order:	111430
Description: Panel	Part Number:	D3655-1
Inspection Dwg: D3655	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

DAS

10

100

30

Measured by:

Audited by:

Reviewed by: 11-89

Prototype Approval:

N/A

Date: 14-09-11

Date: 11/07

Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	
B	09.09.15	Dimensions updated per Dwg Rev B	KJ	



